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1 DECELERATING MECHANISM FOR PRINTED PRODUCTS

2 Background of the Invention

3 The present invention relates generally to apparatus
4 for controlling shingling of printed products conveyed in
5 sequential order from a rotary printing press and variable rotary
6 cutter to a stacking or handling station, and more particularly
7 to novel mechanism for effecting improved deceleration and
8 shingling as each printed product passes from a first high speed
9 conveyor to a slower speed second conveyor.

10 The speed and efficiency of a rotary printing press is
11 dependent in part on the delivery system following passage of a
12 printed web from the printing press, through an in-line finishing
13 system, if utilized, and then through a rotary cutter operative
14 to cut or sever the printed web transversely into finished or
15 unfinished printed products which are then conveyed to a stacking
16 or other handling station. A common press repeat length of
17 conventional rotary printers is 22 1/4 inches which is essentially
18 the circumference of the printing plate cylinder of the press.
19 Other press repeat lengths are also employed. When the press
20 repeat length is a single circumference of the printing plate
21 cylinder, it is a conventional practice to make the knife and
22 anvil cylinders of the rotary cutter twice the diameter of the
23 printing plate cylinder for structural strength purposes. A pair
24 of knife blades carried 180° apart on the periphery of the knife
25 cylinder of the rotary cutter will sever the printed web at the
26 end of each press repeat, assuming there is no blanket or blank
27 gap on the forward end of the press repeat length of web and that
28 the rotational speed of the rotary cutter is in timed relation
29 with the speed of the rotary printing press.

2

1 It is a conventional practice to accelerate movement
2 of the severed printed products as they leave the rotary cutter
3 so as to create a space between the trailing edge of each product
4 and the leading edge of the next successive product leaving the
5 rotary cutter. Conventional practice further entails conveying
6 the severed products at the accelerated rate along a first
7 conveyor path, generally defined by juxtaposed parallel runs of
8 conveyor belts moving at the accelerated speed, such as a speed
9 10% greater than the web speed through the print or blanket
10 cylinders, to a second conveyor path defined by at least one
11 conveyor belt moving at a slower speed. To facilitate shingling
12 of the printed products as they enter and are conveyed by the
13 second conveyor toward a stacking or other handling station, it
14 is desirable that the trailing edge of each successive product
15 be depressed momentarily after the product enters the second
16 conveyor and the trailing edge leaves the first conveyor so that
17 the leading edge of the next succeeding printed product passes
18 over the depressed trailing edge to effect shingling.

19 One known technique for depressing the trailing edge
20 of each successive printed product leaving the first accelerated-
21 movement conveyor path so as to facilitate shingling is to
22 provide a rotary wheel or arm that is rotated in a generally
23 vertical plane at the same rotational speed as the rotary press
24 and on which is mounted a depressor member operative to engage
25 and depress the trailing edge of each successive printed product
26 as it leaves the first conveyor path and enters the slower speed
27 second conveyor path. This technique assists in effecting
28 shingling as long as the repeat length on the rotary press is a
29 full repeat length or is equal to one-half of a full repeat
30 length. In the latter case, a pair of depressors may be mounted
31 on the carrier spaced 180° apart. Alternatively, the rotational
32 speed of the single depressor carrier may be doubled. This,
33 however, creates a problem in that the depressor member is now
34 moving at a tangential velocity greater than the velocity of the
35 printed product received from the accelerated speed conveyor.
36 This tends to increase the surface speed of the product in

3

1 conflict with the action of the slower speed second conveyor path
2 which is trying to slow down the speed of the product.

3 Another problem with prior techniques which utilize a
4 rotary arm carrying one or two diametrically opposed depressor
5 members for depressing the trailing edges of successive products
6 leaving the accelerated-speed conveyor path so as to effect
7 product shingling is that they fail to compensate for situations
8 where the rotary press and rotary cutter are designed to produce
9 trimmed and untrimmed printed products having variable
10 longitudinal lengths measuring a fraction of the press repeat
11 length other than one-half, such as one-third, one-fourth, one-
12 fifth or two-thirds of the printing press repeat length. The
13 latter product lengths are commonly described as resulting from
14 "three-around", "four-around", "five-around", etc., press
15 repeats. Further, the prior techniques for effecting shingling
16 of printed products received from a rotary cutter fail to
17 compensate for ^{any} transverse scrap or non-image waste strip
18 generally produced between ^{each} the press repeat length ^{of web between} or individual
19 finished ^{products made from the repeat length of web} product. As a result, where a plurality of printed
20 products are cut from each press repeat, the point of contact
21 between the ^{press art} depressor member and each successive product takes
22 place progressively closer to the trailing ^{edges} edge of the ^{product} product.
23 This creates cumulative error and significantly inhibits desired
24 shingling between successive printed products as they pass from
25 the accelerated speed conveyor path to the slower conveyor path
26 on the way to a stacker or other handling station.

27 In addition to depressing the trailing edge of each
28 successive printed product passing from the high speed conveyor
29 to the slower speed conveyor to effect shingling of the products
30 disposed on the slower speed conveyor, it is highly desirable
31 that each product be decelerated as it enters the slower conveyor
32 so as to prevent buckling and wrinkling of the individual
33 products. Known systems for delivering printed products in
34 sequential fashion from a printing press effect deceleration of
35 the products after they have entered a reduced speed belt
36 conveyor from a higher speed belt conveyor by causing the leading
37 edge of each product to enter a nip defined between the reduced

1 speed conveyor belts and at least one idler roller.
2 Simultaneously with the leading edge entering this nip, the
3 trailing edge of the product is pressed against the reduced speed
4 conveyor belts by means of a knock-down arm at the upstream end
5 of the second conveyor. A significant problem with this
6 arrangement is that there is no provision for adjustment of the
7 braking action applied to the products, thus failing to enable
8 adjustment of the braking pressure applied to each printed
9 product. Moreover, this arrangement is limited to use with sheet
10 or printed products ^{having gaps between successive products} of equal length.

11 Thus, a need exists for an arrangement or mechanism
12 which facilitates shingling of printed products being conveyed
13 from a first relatively high speed conveyor to a reduced speed
14 conveyor disposed downstream from a variable rotary cutter
15 operative to cut variable length printed products from a web
16 received from a rotary printer, each printed product being
17 precisely engaged at its trailing edge in timed relation to
18 entering the reduced speed conveyor so as to depress the trailing
19 edge and effect engagement with a stationary brake pad to both
20 decelerate the product and facilitate shingling of printed
21 products carried by the reduced speed conveyor.

22 Summary of the Invention

23 One of the primary objects of the present invention is
24 to provide a novel mechanism for effecting improved shingling of
25 printed products conveyed from a variable rotary cutter disposed
26 downstream from a rotary printing press.

27 A more particular object of the invention is to provide
28 a novel mechanism for depressing the trailing edges of successive
29 ^{irregularly spaced} printed products as they pass from an accelerated-speed conveyor
30 to a slower speed conveyor so as to facilitate shingling of the
31 sheet products, the mechanism being operative to engage the
32 trailing edge of each successive printed product at substantially
33 the same location notwithstanding that an irregular gap occurs
34 periodically between successive products.

35 A further object of the present invention is to provide
36 a novel mechanism for momentarily depressing the trailing edges

5

Q 1 of successive ^{irregularly spaced} printed products as they pass from a relatively
2 high speed conveyor to a slower speed conveyor downstream from
3 a rotary cutter so as to facilitate shingling of the products,
4 the mechanism including depressors carried on at least one rotary
5 wheel for cooperation with a brake pad to both depress the
6 trailing edge of each printed product and effect deceleration
7 thereof.

8 Still another object of the present invention is to
9 provide a novel arrangement for decelerating printed products as
10 they are conveyed from a variable rotary cutter through a
11 relatively high speed conveyor to a slower speed conveyor so that
12 the printed products are shingled as they are conveyed by the
13 slower speed conveyor, the arrangement including a plurality of
14 depressor or kicker members carried on a rotating carrier or
15 wheel and operative to accurately engage and depress the trailing
16 edge of each successive printed product as it passes from the
17 high speed conveyor to the slower speed conveyor, and a brake pad
18 cooperative with the depressor members to decelerate each product
19 simultaneously with depressing its trailing edge, the brake pad
20 being adjustable during movement of the products so as to
21 selectively vary the frictional decelerating forces applied to
22 the products and thereby vary the extent of deceleration.

23 A feature of the present invention lies in the
24 provision of a rotatable depressor or kicker wheel having a
25 plurality of depressor or kicker members carried about its
26 periphery, the depressor members being selectively adjustable
27 about the depressor wheel to enable angular phasing with the
28 positions of the knife blades carried on the variable rotary
29 cutter and being coordinated with the repeat pattern of the
30 rotary printing press so as to accurately engage and depress the
31 trailing edge of each successive printed product into cooperation
32 with a brake pad to selectively decelerate the products and
33 facilitate shingling of the printed products irrespective of the
34 removal of dissimilar size transverse scrap or non-image waste
35 ^{strips} ~~scrap~~ between individual products.

36 Another feature of the invention lies in the
37 utilization of brush bristles as the depressor or kicker members

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1 carried about the depressor wheel, the brush bristles being
2 operative to momentarily depress the trailing edge of each
3 successive printed product against the friction pad without
4 adversely affecting the upper printed surfaces of the products.

5 In carrying out the present invention, an arrangement
6 is provided for decelerating successive ^{irregularly spaced} printed products as they
7 are conveyed from a variable rotary cutter by a high-speed belt
8 conveyor to a slower speed belt conveyor, the products having
9 been cut to equal lengths by the rotary cutter after receipt from
10 a rotary web printing press. The variable rotary cutter carries
11 a plurality of knife blades which are adjustable about the
12 periphery of the cutter cylinder so as to cut the printed web to
13 remove any blanket gap from the lead end of the press repeat and
14 then butt cut the web transversely to create a ^{number} ~~member~~ of equal
15 length ^{irregularly spaced} printed products as established by the print cylinder
16 during each revolution or press repeat. Alternatively, the knife
17 blades on the cutter cylinder may be positioned to trim any
18 blanket gap created in a given press repeat length of printed
19 web, and to cut out any bleed trim between the resulting equal
20 length printed products within the given press repeat length of
21 web. As a result of the blanket ^{gap} ~~gaps~~ cut from each press repeat
22 length of web, the equal length printed products conveyed by the
23 high speed belt conveyor to the lower speed belt conveyor will
24 have unequal spacing between the last product of each press
25 repeat and the first product of the next press repeat.


26 The decelerating arrangement of the present invention
27 compensates for any unequal spacing between successive printed
28 products conveyed from the high speed conveyor by providing at
29 least one depressor or kicker wheel rotatable in a substantially
30 vertical plane at the entry end of the slower speed conveyor.
31 The depressor or kicker wheel carries a plurality of depressor
32 or kicker members in the form of generally radial bristle brushes
33 which have outer ends lying on a circle concentric with the axis
34 of rotation of the wheel and having a diameter substantially
35 equal to the outer diameter of the ^{knife} ~~printing plate~~ cylinder. The
36 depressor members are disposed about the kicker wheel in angular
37 circumferential positions corresponding to the angular

7

1 circumferential positions of the cutting knives on the rotary
2 cutter which create the trailing edge of each successive printed
3 product formed by the rotary cutter.

4 When a printed product passes from the high-speed belt
5 conveyor immediately downstream of the rotary cutter into the
6 slower speed belt conveyor, the leading edge of the printed
7 product enters a nip defined between one or more transversely
8 aligned headstop idler rollers and the slower moving belt of the
9 second conveyor. This nip operates to immediately reduce the
10 speed of the entering printed product and is positioned
11 downstream from the depressor wheel so that the trailing edge of
12 the product now underlies and is engaged and depressed by the
13 next depressor brush on the rotating depressor wheel. Because
14 the speed of each print product leaving the high speed belt
15 conveyor is substantially the same, the only variable affecting
16 the timing of entry of the printed products into the slower belt
17 conveyor headstop nip is the spacing between successive products
18 passing downstream from the high speed conveyor, as caused by
19 removal of the blanket gap ^{and any bleed trim} from each press repeat length of
20 printed web. By spacing the depressor or kicker brushes about
21 the depressor or kicker wheel in corresponding angular relation
22 to the knife blades on the rotary cutter which established the
23 trailing edges of successive printed products, the specific
24 depressor or kicker brush on the depressor wheel which
25 corresponds to the last-to-cut ^{trailing edge} knife blade on the rotary cutter
26 will momentarily engage and depress the trailing edge of printed
27 product ^{as it enters} ~~which has just entered~~ the slower belt conveyor so as to
28 enable the leading edge of the next succeeding printed product
29 to pass over the depressed trailing edge and effect shingling
30 between successive products.

31 In order to further decelerate forward movement of each
32 printed product entering the slower belt conveyor, a stationary
33 brake pad is supported slightly below the path traversed by the
34 products passing from the high speed conveyor to the slower speed
35 conveyor and also generally vertically below the rotational axis
36 of the depressor wheel. The brake pad is vertically adjustable
37 so as to cooperate with the depressor or kicker brushes to



1 sandwich the momentarily depressed trailing ends of the printed
2 products between the brushes and the brake pad with sufficient
3 frictional pressure to decelerate the corresponding printed
4 product close to the surface speed of the slower belt conveyor.
5 In this manner, successive printed products are caused to
6 shingle and decelerate irrespective of unequal spacing between
7 the conveyed printed products due to removal of dissimilar size
8 transverse scrap or blanket gaps or non-image waste strips
9 between individual printed products.

10 Further objects, features and advantages of the
11 invention, together with the organization and manner of operation
12 thereof, will become apparent from the following detailed
13 description of the invention taken in conjunction with the
14 accompanying drawings wherein like reference numerals designate
15 like elements throughout the several views.

16 Brief Description of the Drawings

17 FIG. 1 is a perspective view of a variable rotary
18 cutter and associated printed product delivery arrangement in
19 accordance with the present invention;

20 FIG. 2 is a side elevational view of ^{a modified embodiment of} the product
21 delivery arrangement of FIG. 1, the near side frame wall being
22 removed and portions broken away for clarity and the rotary
23 cutter being schematically illustrated in phantom;

24 FIG. 3 is a side view, on an enlarged scale, of a
25 depressor or kicker wheel as employed in the product delivery
26 arrangement of FIG. 2;

27 FIG. 4 is a side edge view of the kicker wheel
28 illustrated in FIG. 3, taken along lines 4-4 of FIG. 3;

29 FIG. 5 is a fragmentary sectional view illustrating the
30 manner of mounting the depressor or kicker brushes on the kicker
31 wheel of FIG. 3;

32 FIG. 6 is a laterally foreshortened generally vertical
33 sectional view illustrating the manner of supporting the
34 adjustable brake pad illustrated in FIG. 2;

1 FIG. 7 is a fragmentary detail view taken substantially
2 along line 7-7 of FIG. 6 illustrating the brake pad and
3 associated support linkage;

4 FIG. 8 is a fragmentary side elevational view taken
5 substantially along line 8-8 of FIG. 6 illustrating the
6 adjustment mechanism for the brake pad;

7 FIG. 9 is a schematic plan view of a length of printed
8 web showing in dash lines the transverse cuts made by the rotary
9 cutter between individual products after leaving the printing
a10 press, and ~~comparing the manner of~~ also showing the points of
11 contact with the depressor wheel of the subject invention as
a12 compared to points of contact ^{made} ~~made~~ with knock-down arms as used
13 in prior printed product delivery systems;

14 FIG. 10 is a schematic diagram illustrating the
15 relative sequence positions of printing cylinders, rotary cutter,
16 and rotary kicker wheel/brake pad arrangement operative to print,
17 cut and shingle printed products in accordance with the present
18 invention.

19 Detailed Description

20 Referring now to the drawings, and in particular to
21 FIG. 1, a printed product delivery system or arrangement for
22 decelerating and shingling printed products in accordance with
23 the present invention is indicated generally at 10. The delivery
24 system or arrangement 10 serves to decelerate and effect
25 shingling of printed products received from a variable rotary
26 cutter, indicated generally at 12, as the products are conveyed
27 from a high speed belt conveyor to a slower speed belt conveyor,
28 as will be described. The variable rotary cutter 12 is
29 preferably of known computer controlled design, such as
30 commercially available from Scheffer, Inc., Merrillville, IN, and
31 includes a rotary knife cylinder 14 and a parallel anvil cylinder
32 16 which are operative to rotate in timed relation in a known
33 manner. The knife cylinder 14 is adapted to carry a plurality
34 of knife or cutter blade assemblies, one of which is indicated
35 at 18, about the periphery or circumference of the knife cylinder
36 so that the knife blade assemblies cooperate with the anvil

10

1 cylinder to cut or sever a continuous web of paper received from
2 a rotary printing press, as schematically illustrated at 20 in
a 3 FIG. 10. ~~As schematically illustrated in FIG. 10,~~ ^{The} the printing
4 press 20 typically includes upper and lower printing plate
5 cylinders 22a and 22b which determine the press repeat length,
6 and a pair of upper and lower blanket cylinders 24a and 24b which
7 print on both sides of a continuous web of paper or the like,
8 indicated at 26 in FIG. 9, passed through the nip defined between
9 the blanket cylinders.

10 The knife cylinder 14 and anvil cylinder 16 of the
11 variable rotary cutter 12 define a nip therebetween which
12 receives the printed web from the rotary printer 20 so as to
13 sever a repeat length of the web into a plurality of
14 substantially equal length printed products, indicated at 26a-e
15 in FIG. 9, separated by transverse butt cuts indicated by dash
16 lines 28. In printing a continuous web with a rotary press, a
17 transverse scrap or blanket gap will frequently be formed at the
a 18 forward or rearward end of ^{each press repeat} ~~the web~~, such as indicated at 30 at
19 the forward end of each press repeat length of web 26. The
20 rotary cutter is operative to remove the blanket gaps as by
21 effecting a transverse cut 32 which defines the leading edge of
22 the first printed product in a press repeat length of web coming
23 from the printer.

24 As is ^{also} known, a length of printed web coming from a
25 rotary printer may also have non-image waste strips formed
26 between the individual equal length printed products, such as
27 26a-e. In this situation, the rotary cutter blades are
28 positioned so as to remove the transverse non-image waste strips
29 between the individual printed products as they are severed and
30 conveyed downstream from the rotary cutter. If desired, the
31 printed web may be passed through an in-line finishing system
a 32 (not shown) prior to passing through the rotary ^{cutter} ~~printer~~ 12. The
33 knife cylinder 14 is illustrated schematically in FIG. 10 as
34 having a diameter twice the diameter of the printing plate
35 cylinders 22a and 22b so that each 180° circumference of the
36 knife cylinder has a similar arrangement of knife cutters to
37 transversely cut or sever a press repeat length of the printed

11

1 web. Alternatively, the printing plate cylinders 22a and 22b may
2 be made of a diameter equal to the diameter of the knife cylinder
3 14 in which event the cutter knives carried about the knife
4 cylinder would be circumferentially spaced to remove the blanket
5 gaps 30 and form substantially equal length printed products
6 along each press repeat length of web by transverse butt cuts 28
7 or cuts sufficient to remove non-image waste strips between
8 successive printed products. As illustrated in FIG. 1, the
9 rotary cutter 12 includes a pair of pin wheels 36a and 36b which
10 ~~are rotatable in timed relation to the anvil cylinder 16 and are~~
11 operative to remove chips or waste strips removed from the cutter
12 cylinder 14 by radial pins disposed about the anvil cylinder ^{in a known manner}.

13 Referring again to FIG. 1, the printed product delivery
14 system or arrangement 10 includes a pair of side frames or plates
15 40a and 40b which are secured in upstanding laterally spaced
16 relation by cross frame members (not shown). The side frame
17 plates 40a and 40b have rollers 42 mounted at their lower edges
18 to facilitate movement in a pair of tracks 44a and 44b disposed
19 transverse to a vertical plane containing the rotational axes of
20 the knife and anvil cylinders 14 and 16 and enabling movement of
21 the product delivery system into close proximity to the rotary
22 cutter or to a position spaced from the rotary cutter to
23 facilitate service or adjustment of the various components of the
24 rotary cutter as well ^{as} providing access to a forward end of the
25 product delivery system. A control panel 46 is mounted on the
26 side frame 40a to facilitate operator control of various
27 functions of the product delivery system.

28 Referring to FIG. 2, the product delivery system 10 has
29 a first relatively high speed belt conveyor, indicated generally
30 at 50, mounted between the side frame plates 40a and 40b such
31 that the high speed conveyor defines an entry nip 52 which is
32 configured and at a height adapted to receive printed products,
33 such as 26a-e, etc., from the rotary cutter 12. The high speed
34 belt conveyor 50 includes a plurality of laterally spaced lower
35 endless belts 54 each of which is reeved about and supported by
36 a plurality of idler rollers including a pair of horizontally
37 aligned rollers 56a and 56b which establish a reach 54a extending

1 horizontally rearwardly or downstream from the receiving nip 52.
2 Each conveyor belt 54 is also reeved about an idler pulley 58
3 which is adjustable to selectively adjust the tension in the
4 conveyor belt with respect to a drive ^{roller} ~~pulley~~ 60 controlled by a
5 suitable drive motor.

6 The high speed belt conveyor 50 also includes a
7 plurality of upper endless belts 64 equal in number to the lower
8 belts 54 and which are reeved about ^a suitable idler ^{roller} ~~pulleys~~ 66a
9 and ^{a roller} ~~66b~~ to define a horizontal reach 64a which overlies the reach
10 54a of ^{the} ~~a~~ lower conveyor ^{belts} ~~belt~~ so as to cooperate therewith to
11 convey printed products from the rotary cutter through the
12 horizontal path defined between reaches 54a and 64a at an
13 accelerated speed. For example, the surface speed imparted to
14 each printed product by the rotary cutter 12 may approach
15 approximately 1,000 fpm which is then accelerated by the high
16 speed conveyor 50 to a surface speed of approximately 1,100 fpm
17 to 1,200 fpm or higher.

18 The product delivery system 10 also includes a slower
19 speed belt conveyor, indicated generally at 70, which is
20 supported between the upstanding side frames 40a and 40b and is
21 operative to receive printed products from the high speed
22 conveyor 50. The belt conveyor 70 includes one or more conveyor
23 ~~belts 72 which preferably conform in number to the high speed~~
24 ~~conveyor belts 54.~~ Each of ^{the} ~~the~~ slower speed conveyor ^{belts} ~~belts~~ 72
25 is reeved about a forward idler ^{roller} ~~pulley~~ 74 and a rearward drive
26 ^{roller} ~~pulley~~ 76 so as to define a horizontal reach 72a parallel to and
27 spaced below the rearward end of the horizontal reach 64a of the
28 upper conveyor belts 64 a distance greater than the thickness of
29 the printed products being conveyed through the product delivery
30 system 10. The idler ^{roller} ~~rollers~~ 74, drive ^{roller} ~~rollers~~ 76 and tension
31 adjustment rollers 78 for the ^{belts} ~~belts~~ 72 are preferably mounted on
32 a carriage 80 which is pivotal about the axis of the drive ^{roller} ~~motor~~
33 76 by means of a control linkage 82 actuated by a solenoid ^{controlled} ~~or~~
34 double acting cylinder 84 which ^{enables} ~~enable~~ the horizontal conveyor
35 reach 72a to be moved downwardly to clear any paper jams or the
36 like.

a 1 The drive ^{roller}~~pulleys~~ 76 ^{is}~~are~~ driven by a drive motor or
2 other suitable drive means so as to establish a surface speed of
3 approximately 300 fpm along the horizontal reach 72a of the
a b conveyor ^{belt belts}~~belts~~ 72. With the high speed belt conveyor 50 and
5 slower speed belt conveyor 70 being supported as aforescribed,
6 each printed product received by the high speed conveyor from the
7 rotary cutter 12 will have its surface speed accelerated as the
8 printed product is conveyed by the high speed conveyor belts 54
9 and 64. As each successive printed product exits from the exit
10 end of the lower high speed conveyor belts 54, as established by
a 11 the idler ^{roller}~~rollers~~ 56b, it will traverse the gap between the
a 12 downstream idler ^{roller}~~rollers~~ 56b of the high speed belt conveyor and
a 13 the upstream idler ^{roller}~~rollers~~ 74 of the slower speed belt conveyor
14 and pass onto the horizontal reach of the slower speed conveyor
15 belts 72.

16 In order to reduce the surface speed of each printed
17 product entering the slower speed belt conveyor from the higher
18 speed belt conveyor, at least one, and preferably two or more
19 axially aligned headstop idler rollers 88 are supported on a
20 transverse support shaft or axle 90 which in turn is supported
21 on the outer ends of one or more pivot arms 92 having their upper
22 ends pivotally mounted on a transverse support shaft 94. The
23 pivot arms 92 and headstop rollers 88 are supported on a
24 horizontal track 96 in a manner to enable horizontal adjustment
a 25 of the headstop rollers 88 relative to the upstream idler ^{roller}~~rollers~~
26 74 of the slower speed conveyor 70. The headstop rollers 88 are
a b urged by gravity against the upper ^{surface surfaces}~~surfaces~~ of the horizontal
a 28 belt ^{reach reaches}~~reaches~~ 72a of the slower speed belt conveyor 70 and define
29 a nip therewith so that the leading edge of each successive
30 printed product will enter the nip and undergo immediate
31 deceleration.

32 The headstop rollers 88 are spaced from the upstream
a 33 idler ^{roller}~~rollers~~ 74 of the slower belt conveyor 70 a distance
34 slightly less than the longitudinal length of the printed
35 products being cut from the printed web so that as the leading
36 edge of each successive printed product enters the headstop nip,

1 its trailing edge will overlies the gap between the high speed and
2 low speed belt conveyors 50 and 70.

3 In accordance with one feature of the present
4 invention, at least one and preferably a pair of axially aligned
5 depressor or kicker wheels, one of which is indicated generally
6 at 100 in FIG. 2, are mounted between the upstanding frame plates
7 40a and 40b for rotation about a transverse rotational axis which
8 overlies the gap between the high speed and low speed conveyors.
9 Referring to FIGS. 3-5, taken with FIG. 2, each of the depressor
10 or kicker wheels 100 includes a generally circular wheel plate
11 102 having a circular center opening 102a and to which is
12 coaxially connected a mounting hub 104 to facilitate mounting of
13 the depressor or kicker wheels on a transverse rotatably driven
14 axle 107 journaled between the upstanding frame plates 40a and
15 40b. The axle 107 is connected to a suitable drive motor (not
16 shown) to effect rotation of the kicker wheels 100 in a
17 counterclockwise direction, as viewed in FIG. 2. Each kicker
18 wheel carries a plurality of depressor or kicker members 106
19 which correspond in number to the number of cutter ^{blades} ~~blade~~ spaced
20 about the cutter cylinder 14 that establish the trailing edges
21 of the printed products formed from the printed web. In the
22 illustrated embodiment, each of the depressor or kicker members
23 106 has a base 106a which may be made of a suitable plastic
24 material and which has a generally arcuate side profile so as to
25 seat on an annular rim surface 102b formed on the wheel 102
26 concentric to its center axis. The kicker members 106 may be
27 secured in selected circumferential position about the axis of
28 the kicker wheel by an annular retaining ring 108 which is
29 releasably attached to the wheel plate by fasteners 110 as
30 illustrated in FIG. 5. The base 106a of each kicker member 106
31 has a plurality of brush bristles 106b secured therein such that
32 the bristles extend generally radially outwardly from the
33 rotational axis of the kicker wheel and have outer ends lying in
34 a circle concentric to the rotational axis of the kicker wheel
35 and having a diameter substantially equal to the diameter of the
36 ~~printing plate cylinder with which the rotary cutter 14 and~~
37 ~~delivery system 10 are used.~~

1 The kicker wheels 100 are positioned to overlies the gap
2 between the high speed and low speed belt conveyors 50 and 70 so
3 that as the kicker wheels rotate, the outer end of each depressor
4 or kicker member 106 will momentarily depress the trailing edge
5 of a printed product whose leading edge has entered the headstop
6 nip, thereby enabling the leading edge of the next successive
7 printed product to pass over the depressed trailing end and
8 shingle therewith.

9 As aforescribed, the depressor or kicker members 106
10 are spaced circumferentially about the kicker wheel plate 102 so
11 as to angularly correspond to each of the cutter blades on the
12 cutter cylinder 14 which create a trailing edge on a printed
13 product formed from the printed web. The rotational speed and
14 angular position of each of the depressor or kicker members 106
15 is in circumferential registry with the corresponding cutter
16 knives on the knife cylinder 14 by means of a conventional
17 harmonic drive or differential gear box, as is known. The
18 registry or phasing may be adjusted by an operator to obtain
19 desired timing in depressing the trailing edge of each successive
20 printed product along with timing of entry of the leading edge
21 onto the headstop nip and adjustment of the surface speed of the
22 conveyor belts 72.

23 In accordance with another feature of the present
24 invention, a brake pad, indicated generally at 114, is supported
25 slightly beneath the path traversed by the printed products as
26 they traverse the gap into the slower speed conveyor 70. The
27 brake pad 114 is positioned to generally vertically underlie the
28 rotational axis of the depressor or kicker wheels 100 and is
29 adjustable to cooperate with each of the depressor or kicker
30 members 106 as it depresses the trailing edge of a printed
31 product so as to sandwich the trailing edge between the kicker
32 member and the brake pad and apply a frictional deceleration
33 to the corresponding printed product. This additional deceleration
34 momentarily imparted to the forwardly moving printed product^{as}
35 its forward edge enters the headstop nip substantially increases
36 the rate of deceleration slowing the printed product down to the
37 substantially slower surface speed of the slower speed conveyor

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1 belts 72, thereby preventing or inhibiting wrinkling or other
2 damage to the printed products.

3 Referring to FIGS. 6-8, taken in conjunction with FIG.
4 2, the brake pad 114 is supported in transverse relation to the
5 conveyor path defined by the high and low speed conveyors 50 and
6 70, respectively, and extends laterally between the upstanding
7 side frame plates 40a and 40b so as to underlie the laterally
8 spaced kicker wheels 100. As illustrated in FIG. 6, the brake
9 pad 114 is supported on the upper surface of a laterally
10 extending support bar 116 which has its opposite ends fixed to
11 slide plates 118a and 118b, both of which are mounted on the
12 inner surfaces of the respective side plates 40a and 40b so as
13 to enable generally vertical movement of the slide plates and
14 thereby the brake pad 114. Each of the slide plates 118a and
15 118b is pivotally secured to the upper end of a pivot link 120
16 having its lower end pivotally connected to a rocker arm 122
17 which in turn is mounted on a transverse pivot shaft 124
18 extending between and rotatably supported by the upstanding frame
19 plates 40a and 40b. In the illustrated embodiment, the end of
20 the pivot shaft adjacent the side frame 40a extends through the
21 side plate and has a gear 126 mounted in fixed relation thereon.
22 The gear 126 is in meshing relation with a worm gear 128 which
23 is mounted coaxially on a control shaft 130. The shaft 130 is
24 supported by a ~~bracket~~ ^{bracket} 132 fixed to the outer surface of the side
25 frame 40a so as to allow rotation of the shaft 130, and thereby
26 the worm gear 128, about its longitudinal axis by means of a
27 handle 134, as illustrated in FIG. 8.

28 With the brake pad 114 supported for substantially
29 vertical adjustment relative to the outer circular path traversed
30 by the outer ends of the kicker members 106, it will be
31 appreciated that the brake pad may be adjusted to vary the
32 frictional relation between the successive kicker members 106 and
33 the trailing edges of the printed products as their trailing
34 edges are depressed, thereby ~~facilitate~~ ^{facilitating} shingling and also
35 decelerating the products more quickly to the slower surface
36 speed of the conveyor belts 72.

As aforescribed, the knife or cutter blades carried by the knife cylinder 14 are adjustable about the periphery of the cutter cylinder so as to cut the printed web 26 to remove any blanket gap, such as indicated at 30 in ~~FIG. 10~~ ^{Fig. 9}, from the lead end of the press repeat length of the web, and then butt cut the web transversely, such as at 28, to create a number of equal length printed products as established by the print cylinders 22a and 22b during each revolution or press repeat. Alternatively, the knife blades on the cutter cylinder may be positioned to trim any blanket gap created in a given press repeat length of printed web and to cut out any bleed trim between the resulting equal length printed products within the given press repeat length of web. As a result of removing the blanket gaps from a press repeat length of web, the printed products cut from the printed web will be equally spaced as they leave the knife cylinder except for the spacing between the trailing edge of the last printed product of a press repeat length of web and the leading edge of first printed product of the next repeat length of web. The decelerating arrangement established by the depressor or kicker wheels 100 and brake pad 114 of the present invention compensates for any uneven spacing between successive printed products conveyed from the high speed conveyor 50 to the slower speed conveyor 70 by spacing the depressor or kicker members about the kicker wheel in ^{angular circumferential} ~~angularly~~ positions corresponding to the knife blades on the knife cylinder which establish the trailing edges of ~~each~~ successive printed products formed from the printed web.

By spacing the depressor or kicker brushes 106 about the circumference of the kicker wheels 100 in corresponding angular relation to the knife blades on the rotary cutter which establish the trailing edges of successive printed products, the depressor or kicker brush on the depressor wheel which corresponds to the last-to-cut knife blade on the rotary cutter will momentarily engage and depress the trailing edge of the corresponding printed product as its leading edge enters the headstop nip of the slower belt conveyor to enable the leading edge of the next succeeding printed product to pass over the

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1 depressed trailing edge and effect shingling. Simultaneously
2 this kicker brush will cooperate with the brake pad 114 to
3 decelerate the corresponding printed product to a speed close to
4 the surface speed of the conveyor belts of the slower belt
5 conveyor. In this manner, successive printed products are caused
6 to shingle and decelerate irrespective of unequal spacing between
7 the conveyed printed products due to removal of dissimilar size
8 transverse scrap or blanket gaps or non-image waste strips
9 between individual printed products.

10 *Ins b3* While a preferred embodiment of the present invention
11 has been illustrated and described, it will be understood to
12 those skilled in the art that changes and modifications may be
13 made therein without departing from the invention in its broader
14 aspects. Various features of the invention are defined in the
15 following claims.
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